Work Order ID 56582

PROTOTYPE

March 1, 2010 2:50:32 PM

Item ID: D3785-3 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bracket

Start Date: 3/01/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/10/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** U **Date:** **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3785	~~RevD~~ Rev. B per prototype								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B 10-3-3			
FLOW CNC Waterjet	1-Cut as per Dwg D3785								
6061 . 080	Dwg Rev: B	Please make Rev. B							
	Prog Rev: B								(3)
	****grain direction 45 degree****								
	2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B 10-3-3			
Quality Control									

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				3			10084
QC	**Memo**	0.00							
Quality Control									
130		0.00							
Brake NC	NC BRAKE					3			
Brake NC	**Memo**	0.00							
	Bend as per Dwg D3785 Rev. B								
140	QC5- Inspect part completeness to step on W/O	0.00				3			10084
QC	**Memo**	0.00							
Quality Control									

SP 10/03/03

Work Order ID 56582

March 1, 2010 2:50:33 PM

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Revision ID:

Item Name: Bracket

Start Date: 3/01/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/10/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Small Fab Small Fab	Small Fab **Memo** 1-counter sink holes as per dwg D3785	0.00 0.00				5 10/03/04			(3)
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				3			10/03/05
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				MA 10/03/05			(X3) Ø

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March 1, 2010 2:50:33 PM

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Required Date: 3/10/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	BR 10-3-5.			(3)			
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 **Memo** START TIME: 10:00Am OVEN TEMPERATURE: 320°F FINISH TIME: 10:30Am	0.00 0.00	JM 10/03/08			(X3)	Ø		
200 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00							

Work Order ID 56582

March 1, 2010 2:50:34 PM

Item ID: D3785-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bracket

Start Date: 3/01/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/10/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location:_____	0.00							
Packaging									
Packaging	**Memo** Mike P.	0.00							
	Not for sale								
220	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

MP 10/03/10

ENG 0100 mark

PROTOTYPE -- ME 10-3-10

Picklist Print

March 1, 2010 2:50:31 PM

Work Order ID: 56582

Parent Item: D3785-3

Parent Item Name: Bracket

Start Date: 3/01/10 **Required Date:** 3/10/10

Comments: IPP Rev:A 08-05-01 new issue DD verifyed by:EC
IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	141.3597	0.3139			

6061-T6 .080 Sheet

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	141.35967		
110630	35.0136		
112141	0.86727		
112763	6.85		
113438	98.6288		113438

10-3-3

(3)

DART AEROSPACE LTD		Work Order:	56582
Description:	BRACKET	Part Number:	D 3785-3
Inspection Dwg:	D3785-3 Rev: B		Page 1 of 1

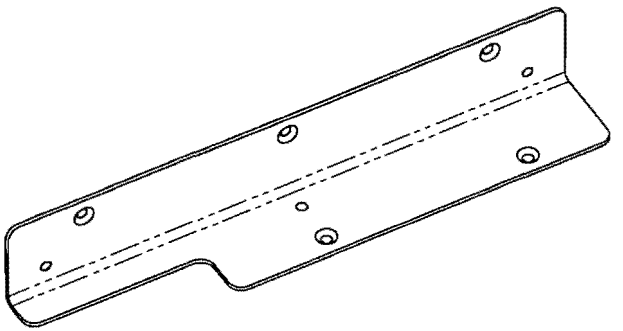
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
ϕ .201	+.005 -.001	.204	X			
4.000	+/- .010	3.998	X			
4.000	+/- .010	3.998	X			
1.500	+/- .010	1.502	X			
.375	+/- .010	.377	X			
2.689	+/- .010	2.688	X			
3.44	+/- .030	3.445	X			
750	+/- .010	.751	X			
9.500	+/- .010	9.502	X			
7.50	+/- .030	7.507	X			
11.00	+/- .030	11.007	X			
1.220	+/- .010	1.222	X			
2.219	+/- .010	2.220	X			
2.44	+/- .030	2.441	X			
.080	+/- .010	.079	X			

Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	10-3-3	Date:	10-03-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3785-3 BRACKET

WO 86882

OK TO MAKE QTY 1

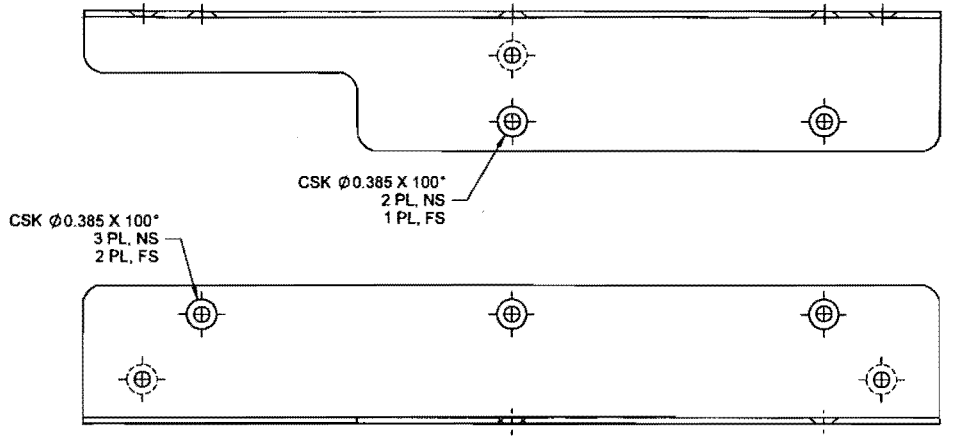
MP 10/3/17

RELEASED 09/10/2018 MP

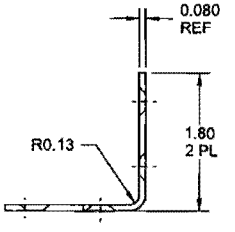
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.26 lbs

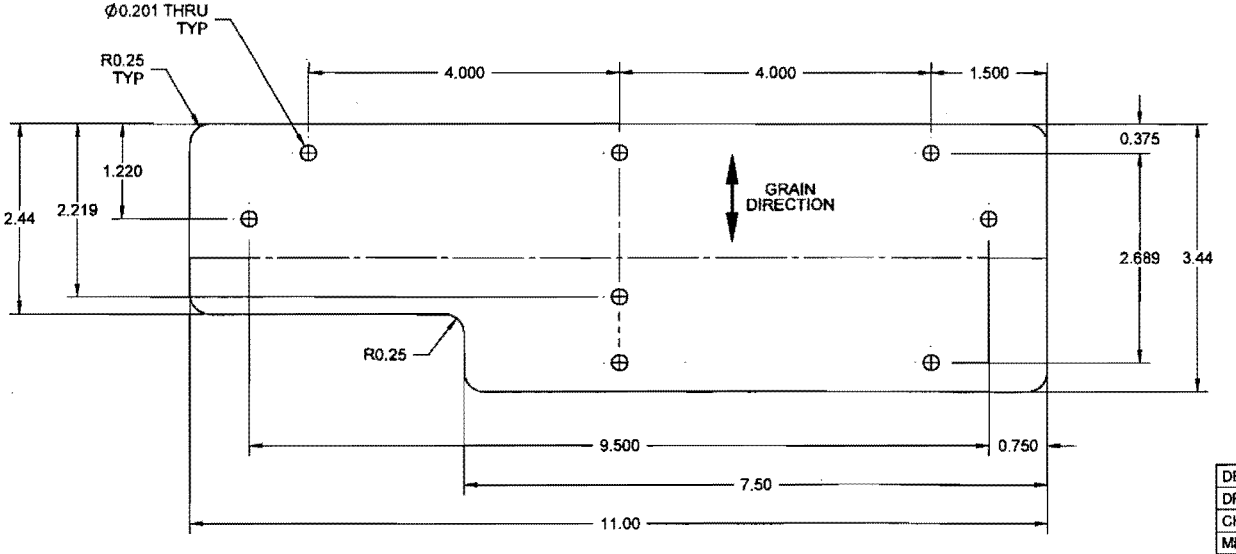
REV.	DESCRIPTION	BY	DATE
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7, DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29

DESIGN	**DART AEROSPACE LTD**	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.	REV. B
MFG. APPR.	D3785	SHEET 1 OF 2
APPROVED	TITLE	SCALE
DE APPR.	BRACKET	NTS
DATE 08.07.18		



D3785-3 BRACKET
MAKE FROM D3785-3F





D3785-3F FLAT PATTERN

M056582

OK TO MAKE
QTY 1
MD

RELEASED
10/3/18

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3785 — REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED	MD	TITLE BRACKET — SCALE NTS
DE APPR.		
DATE 08.07.18		